

Date: Thursday, 9/14/2006 7:29:17 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	INLET VALVE SHAFT
<b>Job Number</b> :	28562		
<b>Estimate Number</b> :	12251		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D34745
<b>This Issue</b> :	9/14/2006	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3474 REV.A
<b>First Issue</b> :	N/A	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	26992	<b>Drawing Revision</b> :	A
		<b>Material</b> :	N/A
<b>Written By</b> :		<b>Due Date</b> :	10/6/2006
<b>Checked &amp; Approved By</b> :		<b>Qty:</b>	4
<b>Comment</b> :	est rev. A 06.04.20 New issue EC	<b>Um:</b>	Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



**Comment:** Qty.: 0.0525 sf(s)/Unit Total: 0.2100 sf(s)  
 304/316 0.018 SHEET

18  
 06 09 18

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET  
 Cut as per Dwg D  
 Dwg Rev: A  
 Prog Rev: A

18  
 06 09 18

(4)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

18  
 06 09 18

(4)

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

06.05.25 (4)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 Deburr if necessary.

MF. 06/09/26

(4)

6.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



**Comment:** INSPECT WORK TO CURRENT STEP

SB 06/09/28

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 06/08/29  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		Parts were made with 18 gauge by mistake, instead of .018						

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 7:29:17 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INLET VALVE SHAFT

Job Number: 28562

Part Number: D34745

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

*PC 6/5/28 (4)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



*(4)*

Comment: FINAL INSPECTION/W/O RELEASE

*SP 06/08/29*

Job Completion



*CU 6009-79*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

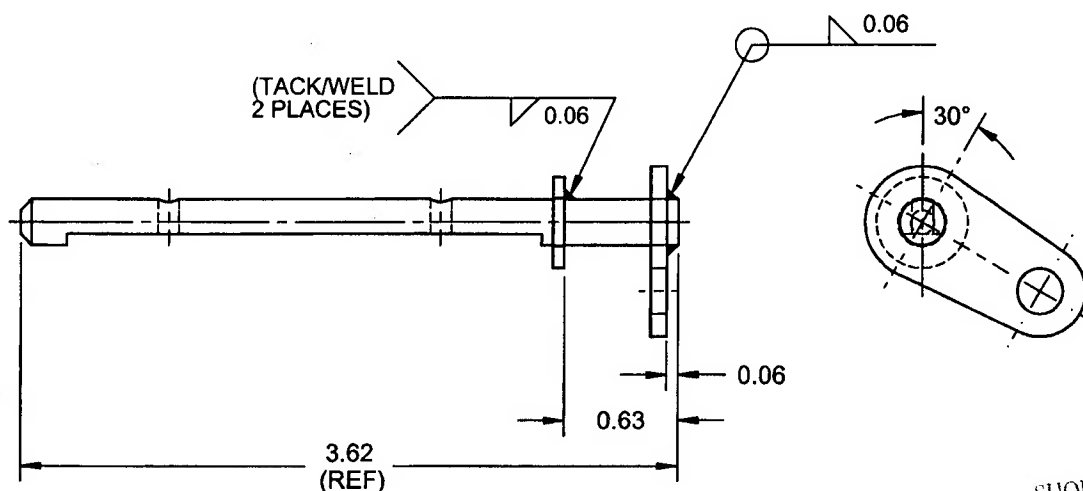
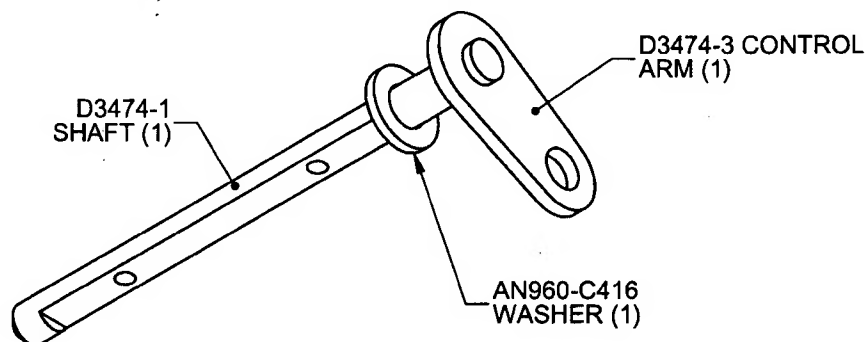
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3474	REV. A SHEET 1 OF 4
DATE 06.01.23		TITLE INLET VALVE SHAFT	SCALE 1:1
A	06.01.23	NEW ISSUE	

*H* 06.04.03



### D3474-041 INLET VALVE SHAFT

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

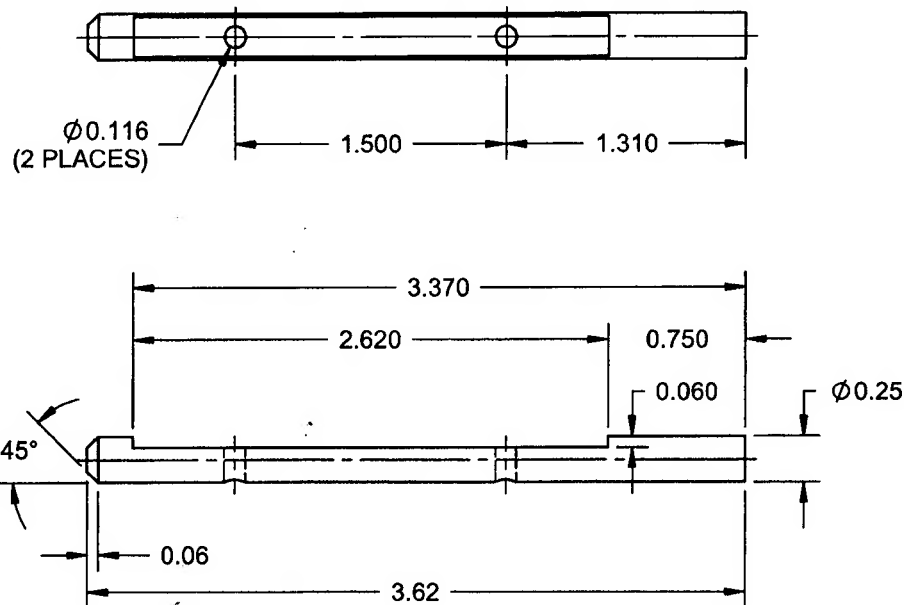
QTY -041	P/N	DESCRIPTION
X	D3474-041	INLET VALVE SHAFT
1	D3474-1	SHAFT
1	D3474-3	CONTROL ARM
1	AN960-C416	WASHER

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3474</b>	REV. A SHEET 2 OF 4
DATE <b>06.01.23</b>		TITLE <b>INLET VALVE SHAFT</b>	SCALE 1:1

*[Signature]* 06.04.03**D3474-1 SHAFT****NOTES:**

- 1) MATERIAL: AISI 303 STAINLESS STEEL 0.25 ROUND BAR  
(REF. DART SPEC. M303R0.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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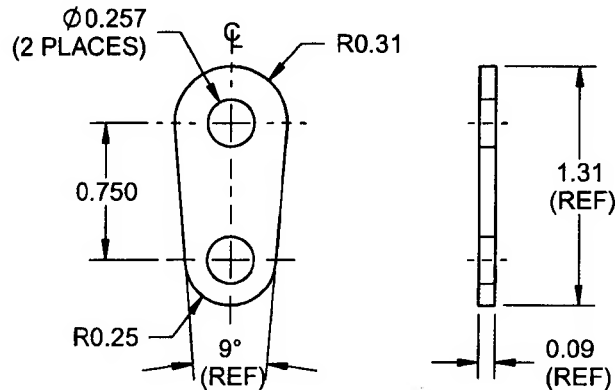
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DATE <b>06.01.23</b>		TITLE <b>INLET VALVE SHAFT</b>	SCALE 1:1

*# 06.04.03*

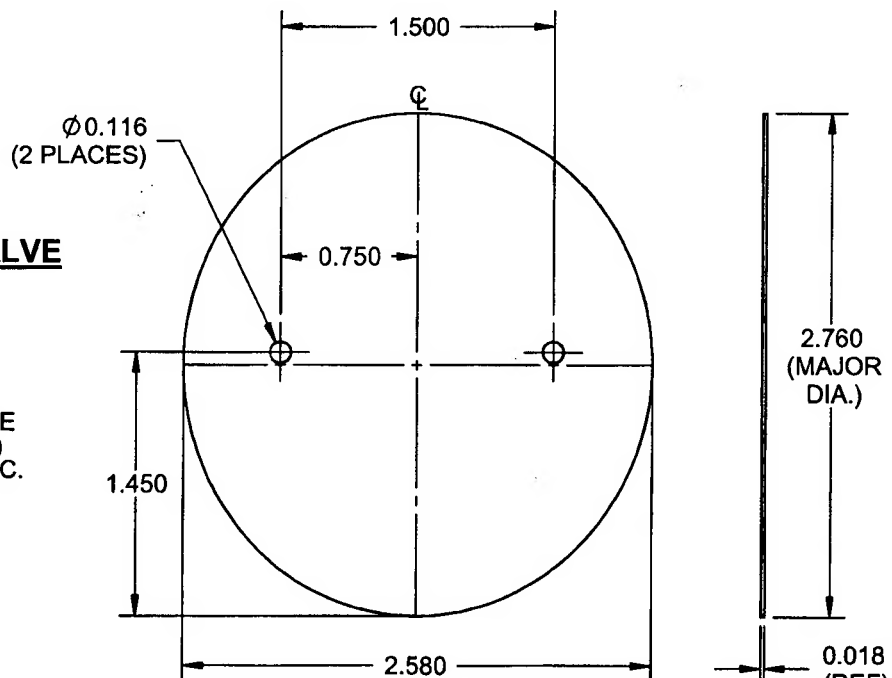
### **D3474-3 CONTROL ARM FLAT PATTERN**

- 1) MATERIAL: AISI 304/316 SS SHEET PER  
MIL-S-5019 (ANNEALED) 2B  
FINISH 13 GAUGE SS  
(0.090 THICK)  
(REF. DART SPEC. M304S13GA)



### **D3474-5 BUTTERFLY VALVE FLAT PATTERN**

- 1) MATERIAL: AISI 304/316 SS  
SHEET PER  
MIL-S-5019  
(ANNEALED) 2B  
FINISH 26 GAUGE  
SS (0.018 THICK)  
(REF. DART SPEC.  
M304S26GA)



#### **NOTES:**

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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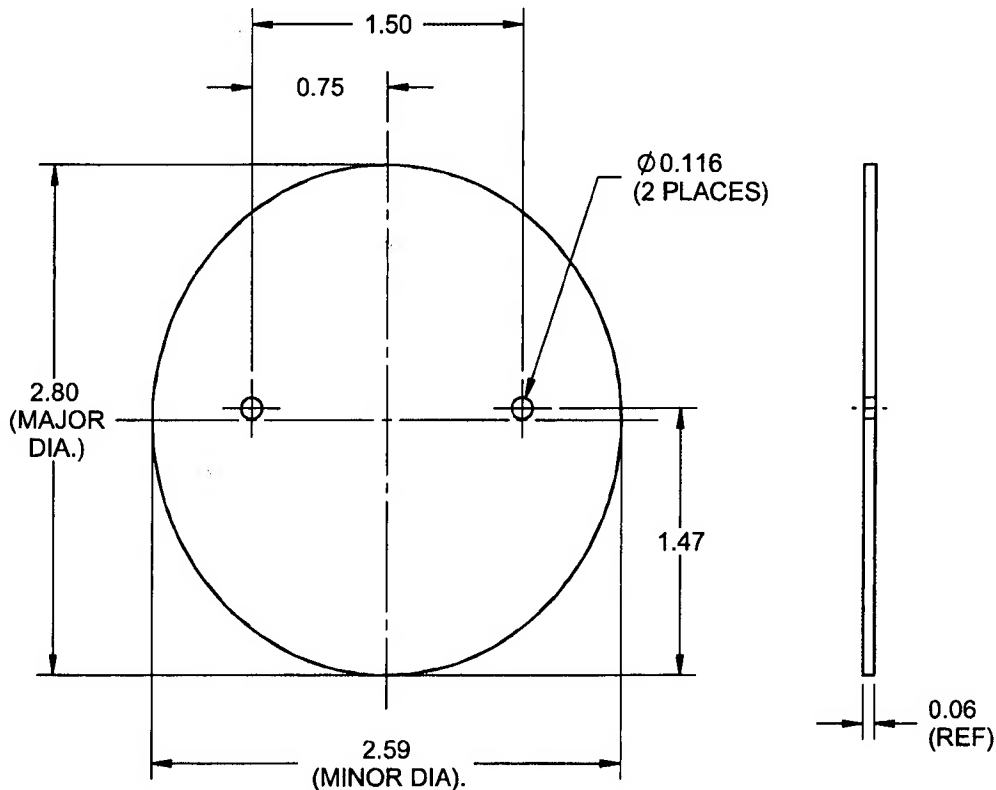
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DATE <b>06.01.23</b>		TITLE <b>INLET VALVE SHAFT</b>	SCALE 1:1

*[Signature]* 06.04.03**D3474-7 BUTTERFLY VALVE SEAL****NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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